

Work Order ID 98847

March-27-13 7:30:15 AM

98847

PRELIMINARY ISSUE

Page 1

Item ID: D4789-3
Revision ID: PRELIM
Item Name: Lower Clevis

Accept

N9000040100

Setup Start *NS1*

Stop *NS2*

Start Date: 3/27/13 Start Qty: 200
Required Date: 4/10/13 Req'd Qty: 200

Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: ML5 Date: 13-03-27 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4789	<u>PAS</u>								
100		0.00							
100	BAND SAW								
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut blank: 3.250" long								
110		0.00							
110	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1- Machine as per Folio FB171								
	FOLIO REV: <u>AA</u>								
	DWG REV: <u>PAS</u>								
	- Deburr								

DAS
08
9-83

D.A. 13/03/29

4 0

Work Order ID 98847

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Page 2

Item ID: D4789-3
Revision ID: PRELIM
Item Name: Lower Clevis

Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Start Date: 3/27/13 Start Qty: 2.00 ***2***
Required Date: 4/10/13 Req'd Qty: 2.00 ***2***

Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00	D.A 13/03/29			4	0		DAG 08 3-83
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				4			13-3-31
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				4			26/3/1

Work Order ID 98847

March-27-13 7:30:15 AM

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Page 3

Item ID: D4789-3
Revision ID: PRELIM
Item Name: Lower Clevis

Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Start Date: 3/27/13 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 4/10/13 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo	0.00 <i>DAS 16 13/04/01</i> 0.00 <i>to PAS Dug 2/4</i>							
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00							
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

POSITIVE RECALL

EFFECTIVE 3/3/27 AUTH [Signature]

RELEASED _____ DATE _____

mf
13-4-02

Picklist Print

March-27-13 7:30:19 AM

Work Order ID: 98847

98847

Parent Item: D4789-3

D4789-3

Parent Item Name: Lower Clevis

Start Date: 3/27/13

Required Date: 4/10/13

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 13-03-08 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.000X04.00 0		Purchased	No				f	17.1900		0.568421			

M6061T6B2 000X04 000

6061T6 Bar 2.00 x 4.00

**

1.104'

13-03-28

Location

Loc Qty

Loc Code

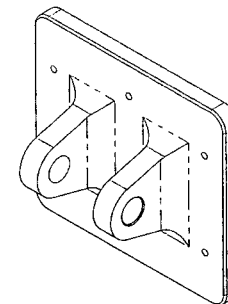
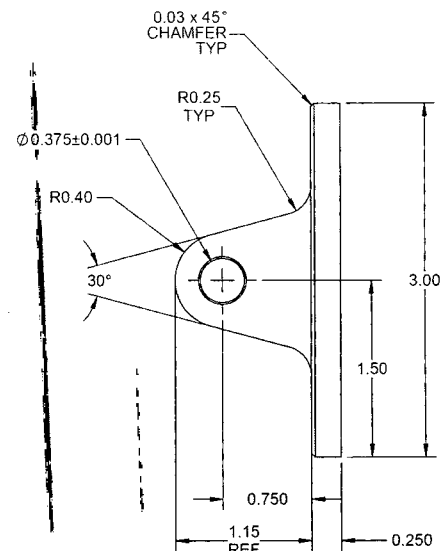
MAT009

17.19

111447

17.19

1.104'



SECRET
UNCONTROLLED COPY
SUSPECT INFORMATION
WITHIN THE
WORK AREA
NO. 98847 MC5
13-03-27

D4789-1 UPPER CLEVIS

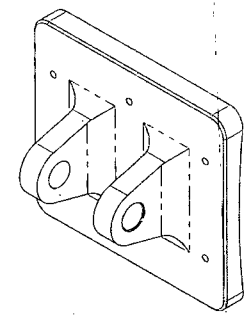
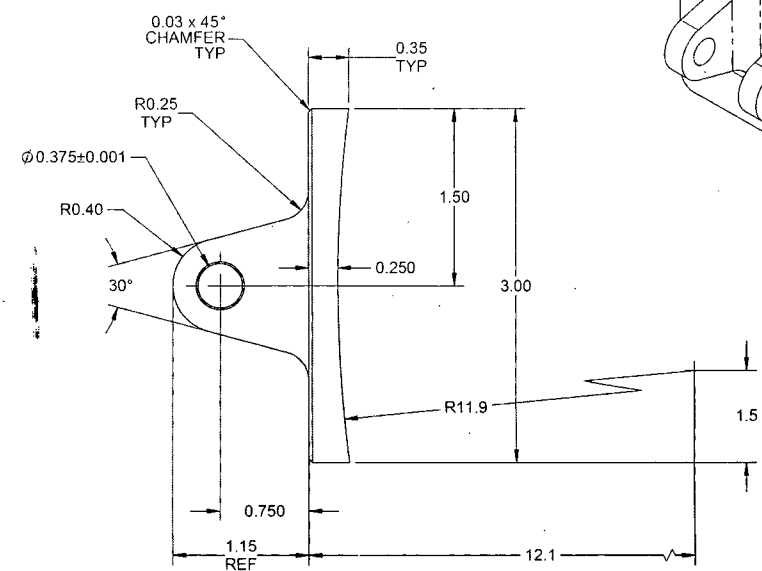
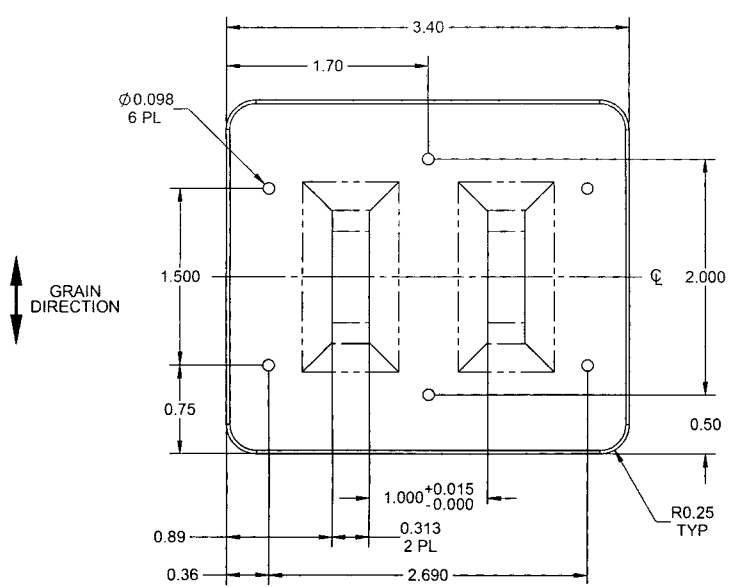
PRELIMINARY ISSUE

13.03.02

- NOTES:**
- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061B
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 0.31 lbs

PA5	NEW ISSUE	RF	13.03.02
REV.	DESCRIPTION		BY DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4789 TITLE CLEVIS	REV. PA
DRAWN	RF		SHEET 1 OF
CHECKED	<i>SC</i>		SCALE
MFG. APPR.			NT
APPROVED			
DE APPR.			
DATE	13.03.02	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUBJECT TO THE FOLLOWING CONDITIONS: THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	

98847



D4789-3 LOWER CLEVIS

PRELIMINARY ISSUE

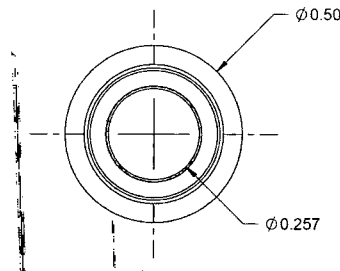
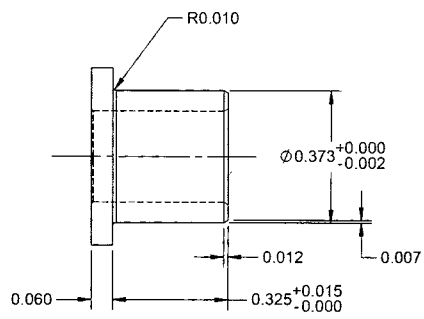
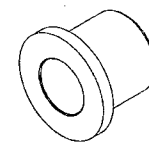
13.03.02

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.34 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO. D4789	REV: PA5 SHEET 2 OF 3
MFG. APPR.		TITLE CLEVIS	SCALE NTS
DE APPR.		<small>COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DATE	13.03.02		

90847



D4789-5 BUSHING

PRELIMINARY ISSUE

~~13~~ 13.03.02

NOTES:

- 1) MATERIAL: AISI 303/304/316 SS ROUND BAR
ASTM A582 OR ASTM A276
REF DART SPEC M303R OR M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 006 4.1
- 7) WEIGHT: 0.01 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DL	DRAWING NO. D4789	REV. PA5 SHEET 3 OF 3
MFG. APPR.		TITLE CLEVIS	SCALE NTS
APPROVED		<small>COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION OF DART AEROSPACE LTD.</small>	
DE APPR.			
DATE	13.03.02		

DART AEROSPACE LTD	Work Order: 98847
Description: LOWER CLEVIS	Part Number: D4789-3
Inspection Dwg: D4789 Rev: PA5	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.40	+/- .030	3.401	✓		Vern	GA-01
1.70	+/- .030	1.700	✓		"	"
φ 0.098	+ .004 / - .001	φ 0.100	✓		"	"
1.500	+/- .010	1.500	✓		"	"
0.75	+/- .030	0.750	✓		"	"
0.89	+/- .030	0.887	✓		H-6	31006
0.36	+/- .030	0.356	✓		"	"
2.690	+/- .010	2.690	✓		Vern	GA-01
0.313	+/- .010	0.310	✓		"	"
1.000	+ .015 / - .000	1.002	✓		"	"
R0.25	+/- .030	R0.250	✓		R-6	ref.
0.50	+/- .030	0.500	✓		H-6	31006
2.000	+/- .010	2.000	✓		Vern	GA-01
0.03 x 45°	+/- .030	0.030 x 45°	✓		"	"
R0.25	+/- .030	R0.250	✓		R6	ref.
φ 0.375	+/- .001	φ 0.3755	✓		Mic	GA-03
0.750	+/- .010	0.749	✓		H-6	31006
0.250	+/- .010	0.248	✓		Vern	GA-01
1.50	+/- .030	1.502	✓		"	"
3.00	+/- .030	3.001	✓		"	"
0.35	+/- .030	0.341	✓		"	"

Measured by: G.A. DAS	Audited by: SL	Preliminary Approval:
Date: 13/03/29	Date: 13-3-31	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15

Receiving Report

Date: 7/4/16

Batch No: M111447

Supplier: MAGNA

Dart P/O: 8535

Packing Slip: Yes ☒ No ☐
 Invoice: Yes ☐ No ☒
 Receipt: Cash ☐ Cr ☒

Release Note Attached: Yes ☒ No ☐ N/A ☐
 Waybill Attached: Yes ☐ No ☒ N/A ☐
 Shipment Complete: Yes ☒ No ☐ N/A ☐
 QCS Inspection: ☒ N/A ☐
 Work Order: B74709 09/04/17 N/A ☐

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
M414NB	625X040	24	0	0	24	
M34TR	625W091	100	0	0	100	
M7075T6	B100-0050	12	0	0	12	

M7075T73 R100

Initials of receiver (if shipment OK) 24 Level 12 [Signature]

Production/Admin:

Date

Received/Costing

Initial

09/04/17
R/C 10744
02

Location _____

Dart Aerospace Ltd

Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7
Phone: (613) 632-3336
Fax: (613) 632-4443

Receiving Slip

Date Apr 17, 2009	Page 1
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Receipt Number RCP00010744

Purchase From:

Magna Stainless
5775 rue Kieran
St Laurent, Quebec H4S 0A3
Canada

Ship To:

Main Finished Goods Location
Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7

Reference	Description	Contact	Vendor Number	PO Number
			VC-MAG002	PO00008535

Vendor Item Number	Item Number	Description	Qty. Received	UOM	Unit Cost	Extended Cost	Arrival Date
	D6207P	Angle Extrusion 1x1x.12 B46909 MINIMUM YIELD TENSILE STRENGTH = 35 KSI MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI MATERIAL: 6061-T6 OR 6511 (QQ-A-200/8) ANGLE EXTRUSION: 1" X 1" X .125" AS PER DWG D6207 REV. A B/N46909	60.0000	f	0.650000	39.00	Apr 17, 2009
	M6061T6B2000X0	6061T6 Bar 2.00 x 4.00 4116 OR PER AMS-QQ-A-200/8 OR AMS 4160 BAR PER AMS-QQ-A-225/8 OR AMS 4117/4128/4115 MATERIAL; 6061-T6 OR 6061-T651/T6510/T6511/T62 B/N111447	20.0000	f	20.100000	402.00	Apr 17, 2009

Comments:



Magna Stainless

5775 Kieran St, Saint-Laurent, Quebec H4S 0A3
Phone: (514) 339-1211 Watts: 1-800-363-6646 Fax: (514) 339-1105

PACKING LIST

I009679

Page: 1 of 1

SOLD TO:
DART AEROSPACE LTD
1270 ABERDEEN STREET

HAWKESBURY, ON
K6A 1K7
Contact: CHANTAL

SHIP TO:
DART AEROSPACE LTD
1270 ABERDEEN STREET

HAWKESBURY, ON
K6A 1K7
Ship Terms: PREPAID

MTR: Y

SPECIAL INSTRUCTIONS

Contact: CHANTAL		Ship To: 1000		7			
Currency		Sales Person		Customer Phone	Customer Fax	Customer PO	
CANADIAN DOLLARS		ERYCK BLAIS		(613) 632-5200	(613) 632-1053	8535	
Sales Order	Terms		Ship Via		Date Ordered	Date Required	Date Shipped
W010589	NET 30 DAYS		NIR:R-557065-1		04/09/09	04/16/09	04/16/09

Ordered	Back Ordered	Unit	Description	Bundle #	Heat #	Shipped
3		PC	ALUMINUM ANGLES AAN 6061 T6 1" x 1" x 1/8" x R/L ✓ 20' 18 LB / 3 PC MUST USE HT: 5850	L020459	5850	3
1		PC	ALUMINUM FLATS AFL 6061 T6 2" x 4" x R/L ✓ 20' 192 LB / 1 PC MUST USE HT: 0724302	L025024	0724302	1
Bundles: 1		Pieces: 1		Total Weight:		210 LB

Received by: _____ Date: _____ Signature: _____

DART

Purchase Order

Date Apr 08, 2009	Page 1
Purchase Order Number PO00008535	

Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7
Phone: (613)632-9577
Fax: (613)632-1053

FAKED
(613)632-1053

Vendor Address:

Magna Stainless
5775 rue Kieran
St Laurent, Quebec H4S 0A3
Canada
Phone (514) 339-1211
Fax (514) 339-1105

Ship To:

Main Finished Goods Location
Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7

Reference	Contact	Vendor Number	PO Date	Terms	Ship Via	Expected Arrival
		VC-MAG002	Apr 08, 2009	N30	yours	Apr 16, 2009

Qty. Ordered	Item Number	Description	Expected Arrival	Drop-Ship	Unit Cost	UOM	Extended Price
✓ 60.0000 9/7/16	D6207P	Angle Extrusion 1x1x.125 Comments: AS PER DWG D6207 REV. A ANGLE EXTRUSION: 1" X 1" X .125" MATERIAL: 6061-T6 OR 6511 (QQ-A-200/8) MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI MINIMUM YIELD TENSILE STRENGTH = 35 KSI B46909	16/04/2009	No	0.650000	f	39.00
24.0000	M4140NB0625X0400	4140 Steel Bar .625 x 4.00 Comments: MATERIAL: 4140 AS PER CF LP ANN BAR PER ASTM A 331 / A 108	16/04/2009	No	29.166666	f	700.00
100.0000	M304TR0675W091	304 RD Tube .675 x .091 Comments: MATERIAL: AISI 304/316 SS SEAMLESS ROUND TUBING OR SCHEDULE 40 SEAMLESS	16/04/2009	No	6.750000	f	675.00
✓ 20.0000 9/7/16	M6061T6B2000X040	6061T6 Bar 2.00 x 4.00 Comments: MATERIAL: 6061-T6 OR 6061-T651/T6510/T6511/T62 BAR PER AMS-QQ-A-225/8 OR AMS 4117/4128/4115 4116 OR PER AMS-QQ-A-200/8 OR AMS 4160	16/04/2009	No	20.100000	f	402.00
12.0000	M7075T6B1500X150	7075 T6 BAR 1.500 x 1.5 Comments: MATERIAL: 7075-T6 OR T651/T6510/T6511/T62 ALUMINUM BAR PER AMS- QQ-A-225/9 OR AMS 4122/4123/4186/4187 OR PER AMS-QQ-A-200/11	16/04/2009	No	16.250000	f	195.00
24.0000	M7075T73R1000	7075-T73 Rd Bar 1.00 Comments: MATERIAL: 7075-T6 OR T651/T6510/T6511/T652 OR T62 ROUND BAR PER AMS-QQ-A-225/9 OR AMS 4122	16/04/2009	No	9.166666	f	220.00

MATERIAL CERTIFICATION
REQ'D UPON DELIVERY

Continued on next page...

PANASIA ALUMINIUM (CHINA) LIMITED

Aluminium Mill Certificate

Cert. No.: PAAV-MC0808005

CUSTOMER: ASA Alloys Inc

P.O. No.: 072216-BB

Contract No.: NIL

Alloy & Temper: 6061-T6511

Standards: ASTM-B221

Container No: ZCSU9009360

Date of shipment: 2008.08.08

QQA-200/8

Chemical Composition (%)

Heat No.	Si	Mg	Fe	Cu	Mn	Zn	Cr	Ti	Al
Standard	0.40-0.80	0.80-1.20	0.7max	0.15-0.40	0.15max	0.25max	0.04-0.35	0.15max	Rem.
20080723201	0.673	0.871	0.256	0.193	0.038	0.035	0.095	0.019	Rem.
20080725301	0.671	0.872	0.254	0.196	0.037	0.031	0.091	0.017	Rem.
20080726301	0.675	0.863	0.253	0.194	0.034	0.033	0.092	0.016	Rem.
20080724302	0.672	0.869	0.256	0.197	0.035	0.034	0.094	0.010	Rem.
20080724401	0.670	0.864	0.259	0.192	0.033	0.032	0.093	0.012	Rem.
20080711302	0.677	0.870	0.252	0.196	0.036	0.030	0.096	0.018	Rem.

Tensile Test Result

Heat No.	Die No.	Customer part No.	Description	Tensile Strength		Yield Strength		Elongation
				N/mm ²	Ksi	N/mm ²	Ksi	
				260 min	35 min	240 min	35 min	10 min
20080723201	T10008		✓ 1 x 0.095 Sq Tube Sq. Corner	295	43	265	39	12.3
20080725301	F10000044		✓ 3/8 x 3 Flat bar Sharp Corner	295	43	260	38	12.1
20080726301	F10030		✓ 1 x 3 Flat bar Sharp Corner	285	42	260	38	12.0
20080724302	F10000087		✓ 2 x 4 Flat bar Sharp Corner	290	42	270	39	12.4
20080724401	T10039		✓ 3/4 x 120 Sq Tube Sq. Corner	290	42	270	39	12.2
20080711302	T10026		✓ 1 x 0.125 Sq Tube Sq. Corner	295	42	265	39	12.5

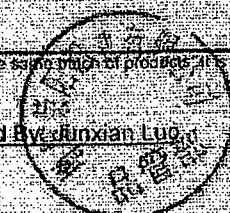
Hardness Test Result

Section No.	HRC	Webster	Other Remarks
T10008	91	15.5	
F10000044	91	15.6	
F10030	90	15.3	
F10000087	90	15.3	
T10039	92	15.9	
T10026	92	15.9	

The above result was done on testing samples and the mill shall guarantee the same quality for the same batch of product. It is certified that this material complies in all respects to the requirements of the above standards latest revision.

QC: Xiaotuan Zhang

Checked By: Junxian Luo



66743
66744
66745
66750
66751
66752

**Purchase Order**

Date Apr 08, 2009	Page 2
Purchase Order Number PO00008535	

Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7
Phone: (613)632-9577
Fax: (613)632-1053


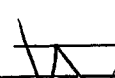
Vendor Address:

Magna Stainless
5775 rue Kieran
St Laurent, Quebec H4S 0A3
Canada
Phone (514) 339-1211
Fax (514) 339-1105

Ship To:

Main Finished Goods Location
Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7

Reference	Contact	Vendor Number	PO Date	Terms	Ship Via	Expected Arrival
		VC-MAG002	Apr 08, 2009	N30	yours	Apr 16, 2009

Qty. Ordered	Item Number	Description	Expected Arrival	Drop-Ship	Unit Cost	UOM	Extended Price
		4123/4124/4186/4187 OR PER AMS-QQ-A-200/11					
<div>MATERIAL CERTIFICATION REQ'D UPON DELIVERY</div>							
Comments:		Tax Summary:		Less:			
		GST 111.55		included tax		0.00	
		ONT PST 0.00		Subtotal		2,231.00	
		Entered By:  CLAVOIE		Total tax		111.55	
		Approved By: 		Total purchase order in CAD Dollars		2,342.55	